

Work Order ID 65042

Wednesday, January 05, 2011 3:04:36 PM



Page 1

Item ID: D350-607-041A

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 1/6/2011 Start Qty: 1.00



Cust Item ID:

Ship

Required Date: 1/13/2011 Req'd Qty: 1.00



Customer:

Thurs Jan 13th

Reference:

Run Start



Approvals: Process Plan: ME

Date: 11-01-05 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D350-607-1

A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-607-041A
CHG001

Sub 11/2

11/01/12

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

11/1/12

120

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D350-607 / DSI 9473
Seal support gusset seam with white sikaflex-291
Batch: M116040
Expiry date: 09/2011

11/01/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Revision ID:

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Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 1/6/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 1/13/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

Sulal12



QC

Memo

0.00

④

Quality Control

*****Ensure label for weight capacity is correct*****

140

Pick Kit

0.00



Packaging

Memo

0.00

11/1/12

Packaging

150

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

Sulal12

④

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 1/13/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-607-041A

Location: B/C

Draft

11/13

170

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

11/01/13

W 11-01-13

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... ..

**Required Date: 1/13/2011**

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
per dwg revC DD 10.01.18 verified by:EC
545 DD 10.04.19 verified by:EC
607-141 and added individual parts of D350-607-141 in DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310-4 		Purchased	No			110	Each	33.0000	4	4			
NUT													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST324				33					
					<u>116075</u>			33					
AN3C11A 		Purchased	No			110	Each	24.0000	4	4			
BOLT													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST351				24					
					<u>112969</u>			24					
AN3C16A 		Purchased	No			110	Each	65.0000	4	4			
Bolt													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST352				65					
					111193			6					
					<u>111425</u>			9					
					<u>115835</u>			50					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, January 05, 2011 3:04:35 PM

Work Order ID: 65042



Parent Item: D350-607-041A



Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 1/6/2011

Required Date: 1/13/2011

Start Qty: 1.00

Required Qty: 1.00

D3953-1 Manufactured No

110 Each

32.0000

2

2



Gas Spring Bracket



11/1/12 S

Location

Loc Qty

Loc Code

ST101

32

52756

4

53760

28

2

D3953-11 Manufactured No

110 Each

2.0000

2

2



Gas Spring Spacer



11/1/12 S

Location

Loc Qty

Loc Code

ST101

2

52767

2

2

D3953-13 Manufactured No

110 Each

30.0000

2

2



Gas Spring Spacer



11/1/12 S

Location

Loc Qty

Loc Code

ST101

30

52761

30

2

D3953-3 Manufactured No

110 Each

1.0000

2

2



Gas Spring Stud, Lid



11/1/12 S B52757

Location

Loc Qty

Loc Code

ST100

1

64020

1

~~B52757~~

B52757

D3953-5 Manufactured No

110 Each

9.0000

2

2



Gas Spring Stud, Base



11/1/12 S

Location

Loc Qty

Loc Code

ST101

9

53758

9

2

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Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 65042

Parent Item: D350-607-041A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 1/6/2011

Required Date: 1/13/2011

Start Qty: 1.00

Required Qty: 1.00

D3953-7 Manufactured No

110 Each

1.0000

2

2



Spring Spacer

Location

Loc Qty

Loc Code

ST101

1

63674

1

D3953-9 Manufactured No

110 Each

13.0000

4

4



Gas Spring Washer

Location

Loc Qty

Loc Code

ST100

11

64450

11

ST103

2

60008

2

D3969-1 Manufactured No

110 Each

32.0000

2

2



Spring (Basket Lid)

Location

Loc Qty

Loc Code

ST272

32

52889

21

53759

11

MS21043-3 Purchased No

110 Each

1,731.000

8

8



Nut

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

1655

112314

1655

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 65042

Parent Item: D350-607-041A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 1/6/2011

Required Date: 1/13/2011

Start Qty: 1.00

Required Qty: 1.00

MS24665-2-12 Purchased No

110 Each

77.0000

4

4



1/11/12 SP

COTTER PIN

Location

Loc Qty

Loc Code

ST309

77

111499

77

NAS1149C0332R Purchased No

110 Each

5,107.000

8

8



1/11/12 SP

Washer

Location

Loc Qty

Loc Code

ST297

5107

115000

125

115698

35

115832

9

116025

1938

116304

3000

NAS1149C0432R Purchased No

110 Each

208.0000

4

4



1/11/12 SP

Washer

Location

Loc Qty

Loc Code

ST297

208

114292

50

114742

67

116304

91

D350-607-241 Manufactured No

140 Each

2.0000

1

1



B64449 1/11/12 SP

Basket Clamp Assembly

Location

Loc Qty

Loc Code

FG022

2

64449

2

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 65042

Parent Item: D350-607-041A



Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 1/6/2011





Required Date: 1/13/2011

Start Qty: 1.00







Required Qty: 1.00

D2022-101 Manufactured No 110 Each 81.0000 2 2
  11/1/12sf
 Spacer

Location	Loc Qty	Loc Code
ST504	81	
50746	23	
52325	10	
63318	48	

D2221 Manufactured No 110 Each 0.0000 1 1
  11/1/12sf
 350 Basket Base
 D2258-200 Manufactured No 110 Each 11.0000 1 1
  11/1/12sf
 Placard 200lb

Location	Loc Qty	Loc Code
ST505	11	
64284	11	

D2512 Manufactured No 110 Each 0.0000 1 1
  11/1/12sf
 Basket Lid 205/350
 D2530 Manufactured No 110 Each 0.0000 1 1
  11/1/12sf
 Handle Weldment
 D2535 Manufactured No 110 Each 64.0000 2 2
  11/1/12sf
 Spring

Location	Loc Qty	Loc Code
ST504	64	
58331	24	
64280	40	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 65042

Parent Item: D350-607-041A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 1/6/2011

Required Date: 1/13/2011

Start Qty: 1.00

Required Qty: 1.00

D2537

Manufactured No

110 Each

36.0000

2

2



Bushing



11/1/12 SP

Location

Loc Qty

Loc Code

ST504

36

62393

6

64064

30

2

D2931

Manufactured No

110 Each

744.0000

2

2



Bumper



11/1/12 SP

Location

Loc Qty

Loc Code

ST504

744

46064

744

2

AN3-16A

Purchased No

110 Each

108.0000

2

2



Bolt



11/1/12 SP

Location

Loc Qty

Loc Code

ST352

108

114752

58

116419

50

2

AN4-7A

Purchased No

110 Each

121.0000

2

2



Bolt



11/1/12 SP 10

Location

Loc Qty

Loc Code

ST356

121

113226

71

115373

50

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 65042

Parent Item: D350-607-041A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 1/6/2011

Required Date: 1/13/2011

Start Qty: 1.00

Required Qty: 1.00

AN5-17A Purchased No 110 Each 58.0000 4
Bolt

Location	Loc Qty	Loc Code
ST339	58	
115594	8	
116003	50	

11/1/12 SP

MS20600-AD4W3 Purchased No 110 Each 1,383.000 2
Cherry Rivets

Location	Loc Qty	Loc Code
ST321	1383	
107939	754	
111636	629	

11/1/12 SP

AN960JD416 NAS1149D0463J Purchased No 110 Each 30.0000 2
Washer

Location	Loc Qty	Loc Code
ST300	24	
113288	24	
ST356	6	
115622	6	

11/1/12 SP

AN960JD516 NAS1149D0563J Purchased No 110 Each 34.0000 4
Washer

Location	Loc Qty	Loc Code
ST	34	
103694	18	
107534	12	
109287	4	

11/1/12 SP

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 65042

Parent Item: D350-607-041A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 1/6/2011

Required Date: 1/13/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD8^{*} NAS1149DN832J Purchased No
Washer

110 Each 10.0000 2 2



M116513 11/1/12

Location

Loc Qty

Loc Code

ST347

10

105059

10

MS21042L3 Purchased No
Nut

110 Each 2,544.000 10 10



11/1/12

Location

Loc Qty

Loc Code

ST300

2544

114784

9

115835

831

116373

4

116391

900

116540

800

MS21042L4 Purchased No
Nut

110 Each 4,180.000 2 2



11/1/12

Location

Loc Qty

Loc Code

ST300

4180

1123143

2

115589

10

115621

668

116188

3500

2

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Parent Item: D350-607-041A



Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 1/6/2011

Required Date: 1/13/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

110

Each

1,185.000

4



11/1/25 (D)

Nut

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

1159

115156

5

115594

500

116104

158

116105

496

✓

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DART SERVICE INSTRUCTION

TO AMEND DRAWING D350-607 REV. F OR SUBSEQUENT APPROVED REVISION

REF CANADIAN STC: SH94-14

FAA STC: SR00213NY

EASA STC: EASA.IM.R.S.01405

#65040

THE PURPOSE OF THIS DART SERVICE INSTRUCTION (DSI), IS TO PROVIDE OPERATORS OF AS350 / 355 ROTORCRAFT EQUIPPED WITH DART D350-607-041 HELI UTILITY BASKETS WITH AN UPGRADE KIT TO REPLACE THE EXISTING LID PROP ARM WITH 2 GAS SPRINGS.

FOR OPERATORS EQUIPPED WITH D350-607-043/-045/-047 HELI UTILITY BASKETS THIS DSI WILL PROVIDE AN UPGRADE KIT TO REPLACE THE EXISTING LID PROP ARM WITH 1 GAS SPRING.

ITEM No.	QTY -141	QTY -143	QTY -145	PART NUMBER	DESCRIPTION
1	X			D350-607-141	AUTOMATIC LID OPENER INSTL (FOR USE ON -041 BASKET*)
2		X		D350-607-143	AUTOMATIC LID OPENER INSTL (FOR USE ON -043/-047 BASKET*)
3			X	D350-607-145	AUTOMATIC LID OPENER INSTL (FOR USE ON -045 BASKET*)
4	2		1	D3953-1	GAS SPRING BRACKET
5	2	1	1	D3953-3	GAS SPRING STUD (LID)
6	2	1	1	D3953-5	GAS SPRING STUD (BASE)
7	2	1	1	D3953-7	GAS SPRING SPACER
8	4	2	2	D3953-9	GAS SPRING WASHER
9	2	1	1	D3953-11	GAS SPRING SPACER
10	2		1	D3953-13	GAS SPRING SPACER
11		1		D3953-15	GAS SPRING BRACKET
12		1		D3953-17	GAS SPRING SPACER
13	2	1	1	D3969-1	GAS SPRING
14	4	2	2	AN3C11A	BOLT
15		2		AN3C15A	BOLT
18	4		2	AN3C16A	BOLT
19	4	2	2	AN310-4	CASTELLATED NUT
20	8	4	4	MS21043-3	NUT
21	4	2	2	MS24665-212	COTTER PIN
22	8	4	4	NAS1149C0332R	WASHER (OR AN960C10L)
23	4	2	2	NAS1149C0432R	WASHER (OR AN960C416L)

***NOTE:** FOR CUSTOMERS WISHING TO ORDER NEW BASKETS WITH THE LID OPENER PRE-INSTALLED USE THE FOLLOWING NUMBERS:

D350-607-041 BASKET WITH AUTOMATIC LID OPENER INSTALLED = D350-607-041A

D350-607-043 BASKET WITH AUTOMATIC LID OPENER INSTALLED= D350-607-043A

D350-607-045 BASKET WITH AUTOMATIC LID OPENER INSTALLED = D350-607-045A

D350-607-047 BASKET WITH AUTOMATIC LID OPENER INSTALLED = D350-607-047A

C	SHEET 1 PL, -143 INSTL, ITEM 6 QTY WAS 2, ITEM 7 WAS 0.	AJS	09.11.11
B	SHT 1 P/L ITEM 22 WAS NAS1149C0332 ITEM 23 WAS NAS1149C0432H. ALL OTHER SHEETS UPDATED ACCORDINGLY. (REASON: DRAFTING ERROR) INSTALLATIONS RENAMED.	AJS	09.11.06
A	NEW ISSUE	AJS	09.09.15
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	N/A	DSI 9473	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		AUTOMATIC LID OPENER INSTL	NTS
DATE	09.11.11	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 09.11.11
CERT. NO.: SH94-14
ISSUE NO.: 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

FOR D350-607-041 BASKETS, REPLACE THE EXISTING D2332-041 PROP ARM ASSEMBLY AS FOLLOWS:

D350-607-141 AUTOMATIC LID OPENER INSTALLATION

#65040

NOTE: ONCE THIS MODIFICATION IS COMPLETE YOU WILL NOT BE ABLE TO RE-INSTALL THE D2332-041 PROP ARM.

- 1) REMOVE THE D2332-041 PROP ARM.
- 2) GRIND FLUSH THE D2327-3 SPACER BUSHING ON BOTH ENDS OF THE BASKET AS SHOWN IN FIGURE 1 (IT IS PERMISSIBLE TO GRIND ALL 4 SPACERS FLUSH). TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4.
- 3) LOCATE THE D3953-1 GAS SPRING BRACKET AS SHOWN IN FIGURE 1. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET LID SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL A. INSTALL THE D3953-1 GAS SPRING BRACKET & D3953-13 GAS SPRING SPACER USING 2X AN3C16A BOLT, 2X NAS1149C0332R WASHER & 2X MS21043-3 NUT AS SHOWN IN VIEW E-E.
- 4) LOCATE THE D3953-5 GAS SPRING STUD AS SHOWN IN FIGURE 1. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET BASE SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL B. FASTEN D3953-5 IAW VIEW F-F USING 2X AN3C11A BOLT, 2X NAS1149C0332R WASHER & 2X MS21043-3 NUT.
- 5) INSTALL 1X D3953-11 GAS SPRING SPACER ONTO THE D3953-5 STUD AS SHOWN IN VIEW F-F. INSTALL THE LARGE END OF THE D3969-1 GAS SPRING SPRING ONTO THE D3953-5 GAS SPRING STUD AND FASTEN IN PLACE USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432R WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW F-F. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.
- 6) INSERT THE D3953-3 GAS SPRING STUD INTO THE D3953-1 GAS SPRING BRACKET & INSERT THE D3953-7 GAS SPRING SPACER ONTO THE D3953-3 GAS SPRING AS SHOWN IN VIEW E-E. RAISE THE BASKET LID AND INSTALL THE ROD END OF THE D3969-1 GAS SPRING ONTO THE D3953-3 GAS SPRING STUD USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432R WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW E-E. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.

NOTE: THE D3953-3 GAS SPRING STUD CAN BE HELD IN PLACE WITH A $\frac{5}{16}$ OPEN END SPANNER / WRENCH.

NOTE: WITH THE LID IN THE CLOSED POSITION THE GAS SPRING SHOULD NOT BE FULLY COMPRESSED.




- 7) REPEAT STEPS 2 THROUGH 6 AT THE OTHER END OF THE BASKET.
- 8) TEST THE INSTALLATION. IF INSTALLED PROPERLY THE GAS SPRINGS SHOULD ASSIST THE BASKET USER IN BOTH OPENING AND CLOSING THE BASKET LID.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 09.11.11
CERT. NO.: SH94-14
ISSUE NO.: 4

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CHECKED		DRAWING NO.	REV. C
MFG. APPR.	N/A	DSI 9473	SHEET 2 OF 8
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

FOR D350-607-043/-047 BASKETS REPLACE THE EXISTING D2332-041 PROP ARM ASSEMBLY AS FOLLOWS:

D350-607-143 AUTOMATIC LID OPENER INSTALLATION

#65042

NOTE: THIS KIT MAY BE INSTALLED AT EITHER END OF THE BASKET. HOWEVER, THE PROP ARM MUST BE REMOVED IN EITHER CASE AS IT WILL INTERFERE WITH THE FUNCTION OF THE GAS SPRING.




- 1) REMOVE THE D2332-041 PROP ARM.
- 2) GRIND FLUSH THE D2327-3 SPACER BUSHING ON THE END OF THE BASKET WHERE THE LID OPENER IS BE INSTALLED AS SHOWN IN FIGURE 2 (IT IS PERMISSIBLE TO GRIND ALL 4 SPACERS FLUSH). TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4.
- 3) LOCATE THE D3953-15 GAS SPRING BRACKET AS SHOWN IN FIGURE 2. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET LID SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL C. INSTALL THE D3953-15 GAS SPRING BRACKET & D3953-17 GAS SPRING SPACER USING 2X AN3C15A BOLT, 2X NAS1149C0332R WASHER & 2X MS21043-3 NUT AS SHOWN IN VIEW G-G.
- 4) LOCATE THE D3953-5 GAS SPRING STUD AS SHOWN IN FIGURE 2. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET BASE SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL D. INSTALL 2X AN3C11A BOLT, 2X NAS1149C0332R WASHER & 2X MS21043-3 NUT AS SHOWN IN VIEW H-H. INSTALL THE ROD END OF THE D3969-1 GAS SPRING ONTO THE D3953-3 GAS SPRING STUD USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432R WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW H-H. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.
- 5) INSERT THE D3953-3 GAS SPRING STUD INTO THE D3953-15 GAS SPRING BRACKET & INSERT THE D3953-7 GAS SPRING SPACER ONTO THE D3953-3 GAS SPRING STUD AS SHOWN IN VIEW G-G. RAISE THE BASKET LID AND INSTALL THE D3969-1 GAS SPRING ONTO THE D3953-3 GAS SPRING STUD AND FASTEN IN PLACE USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432R WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW G-G. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.

NOTE: THE D3953-3 GAS SPRING STUD CAN BE HELD IN PLACE WITH A $\frac{9}{16}$ OPEN END SPANNER / WRENCH.

NOTE: WITH THE LID IN THE CLOSED POSITION THE GAS SPRING SHOULD NOT BE FULLY COMPRESSED.

- 6) TEST THE INSTALLATION. IF INSTALLED PROPERLY THE GAS SPRING SHOULD ASSIST THE BASKET USER IN BOTH OPENING AND CLOSING THE BASKET LID.

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CERT. NO.:	SH94-14
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

FOR D350-607-045 BASKETS REPLACE THE EXISTING D2332-041 PROP ARM ASSEMBLY AS FOLLOWS:

D350-607-145 AUTOMATIC LID OPENER INSTALLATION

#65042

NOTE: THIS KIT MAY BE INSTALLED AT EITHER END OF THE BASKET. HOWEVER, THE PROP ARM MUST BE REMOVED IN EITHER CASE AS IT WILL INTERFERE WITH THE FUNCTION OF THE GAS SPRING.

- 1) REMOVE THE D2332-041 PROP ARM.
- 2) GRIND FLUSH THE D2327-3 SPACER BUSHING ON THE END OF THE BASKET WHERE THE LID OPENER IS BE INSTALLED AS SHOWN IN FIGURE 1 (IT IS PERMISSIBLE TO GRIND ALL 4 SPACERS FLUSH). TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4.
- 3) LOCATE THE D3953-1 GAS SPRING BRACKET AS SHOWN IN FIGURE 1. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET LID SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL A. INSTALL THE D3953-1 GAS SPRING BRACKET & D3953-13 GAS SPRING SPACER USING 2X AN3C16A BOLT, 2X NAS1149C0332R WASHER & 2X MS21043-3 NUT AS SHOWN IN VIEW E-E.
- 4) LOCATE THE D3953-5 GAS SPRING STUD AS SHOWN IN FIGURE 1. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET BASE SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL B. FASTEN D3953-5 IAW VIEW F-F USING 2X AN3C11A BOLT, 2X NAS1149C0332R WASHER & 2X MS21043-3 NUT.
- 5) INSTALL 1X D3953-11 GAS SPRING SPACER ONTO THE D3953-5 STUD AS SHOWN IN VIEW F-F. INSTALL THE LARGE END OF THE D3969-1 GAS SPRING SPRING ONTO THE D3953-5 GAS SPRING STUD AND FASTEN IN PLACE USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432R WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW F-F. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.
- 6) INSERT THE D3953-3 GAS SPRING STUD INTO THE D3953-1 GAS SPRING BRACKET & INSERT THE D3953-7 GAS SPRING SPACER ONTO THE D3953-3 GAS SPRING AS SHOWN IN VIEW E-E. RAISE THE BASKET LID AND INSTALL THE ROD END OF THE D3969-1 GAS SPRING ONTO THE D3953-3 GAS SPRING STUD USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432R WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW E-E. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.

NOTE: THE D3953-3 GAS SPRING STUD CAN BE HELD IN PLACE WITH A $\frac{9}{16}$ OPEN END SPANNER / WRENCH.

NOTE: WITH THE LID IN THE CLOSED POSITION THE GAS SPRING SHOULD NOT BE FULLY COMPRESSED.




- 7) TEST THE INSTALLATION. IF INSTALLED PROPERLY THE GAS SPRING SHOULD ASSIST THE BASKET USER IN BOTH OPENING AND CLOSING THE BASKET LID.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

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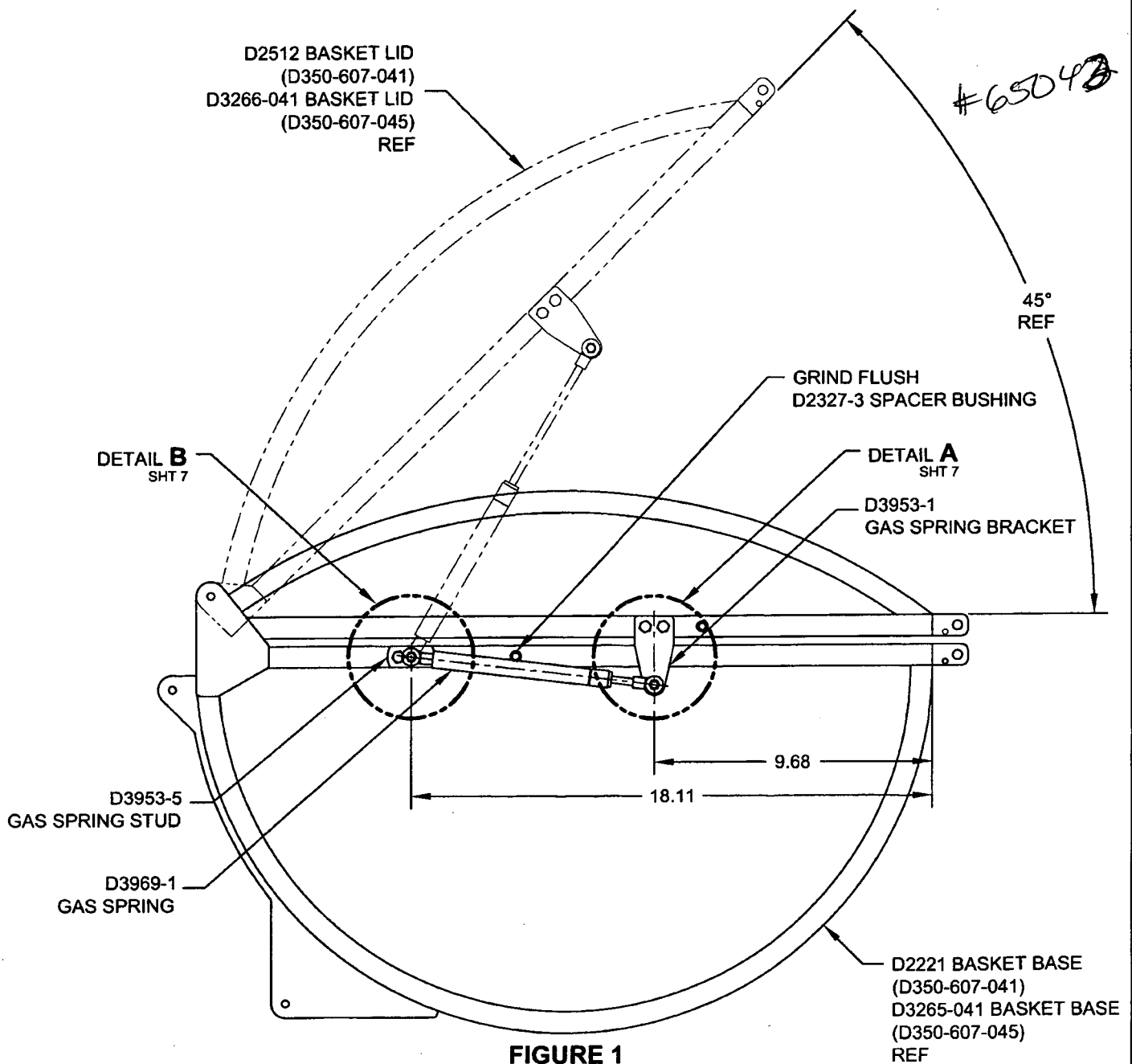


FIGURE 1

D350-607-141 AUTOMATIC LID OPENER INSTALLATION
(BOTH ENDS)




D350-607-145 AUTOMATIC LID OPENER INSTALLATION
(1 END ONLY)

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DAO # 01-O-01

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

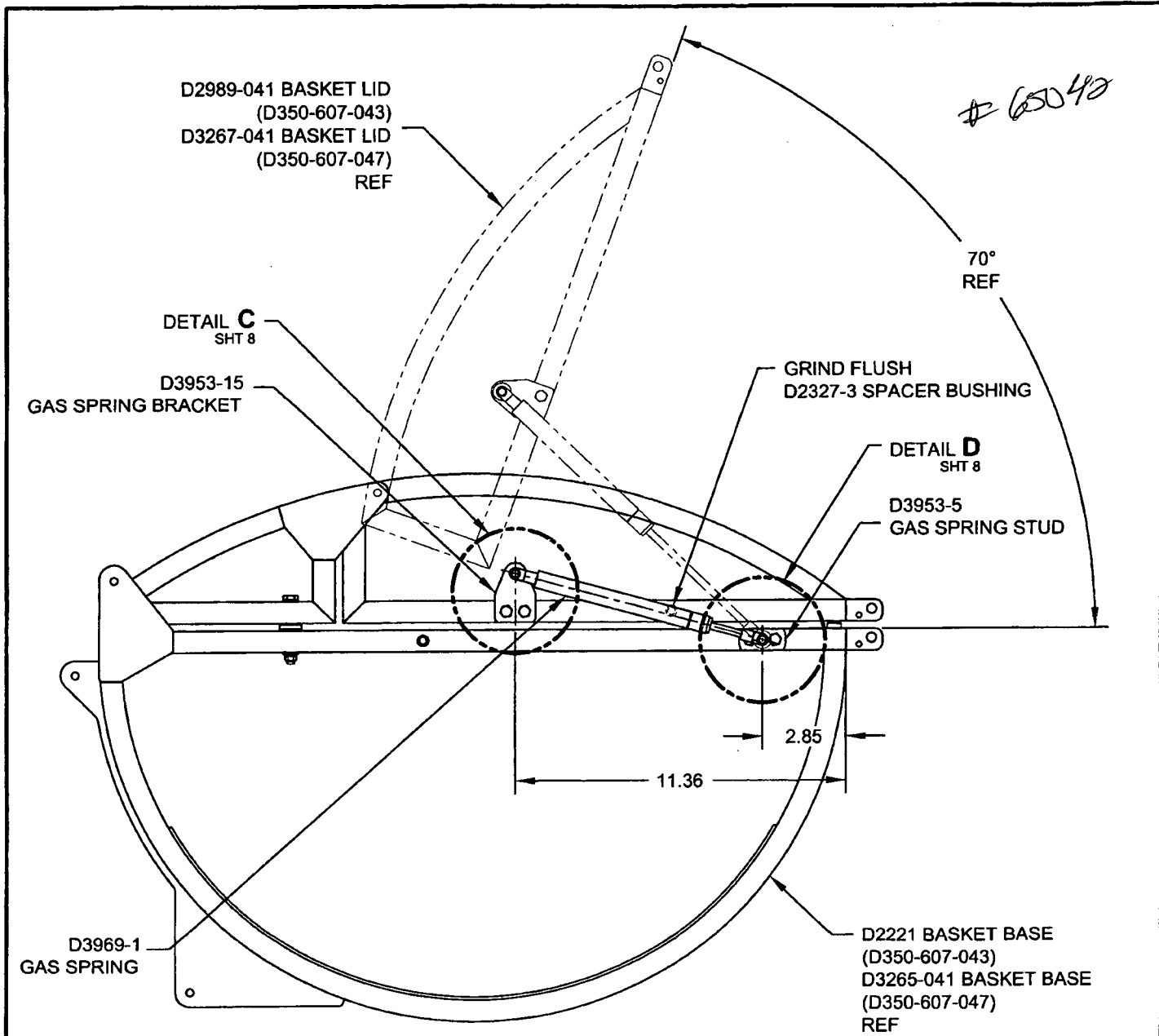


FIGURE 2
D350-607-143 AUTOMATIC LID OPENER INSTALLATION
 (1 END ONLY)

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

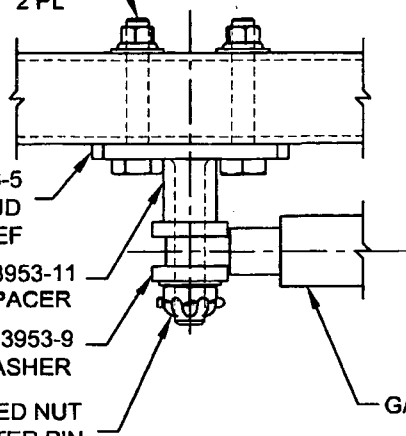
AN3C11A BOLT
NAS1149C0332R WASHER
MS21043-3 NUT
2 PL

D3953-5
GAS SPRING STUD
REF

D3953-11
GAS SPRING SPACER

D3953-9
GAS SPRING WASHER

AN310-4 CASTELLATED NUT
MS24665-212 COTTER PIN
NAS1149C0432R WASHER

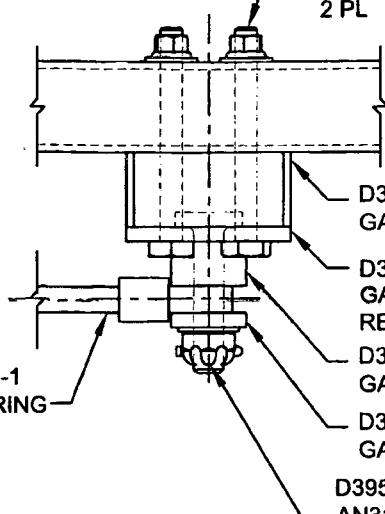


VIEW F-F

AN3C16A BOLT
NAS1149C0332R WASHER
MS21043-3 NUT
2 PL

#65042

D3969-1
GAS SPRING
REF



D3953-13
GAS SPRING SPACER

D3953-1
GAS SPRING BRACKET
REF

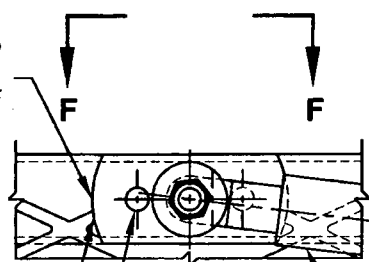
D3953-7
GAS SPRING SPACER

D3953-9
GAS SPRING WASHER

D3953-3 GAS SPRING STUD
AN310-4 CASTELLATED NUT
MS24665-212 COTTER PIN
NAS1149C0432R WASHER

VIEW E-E

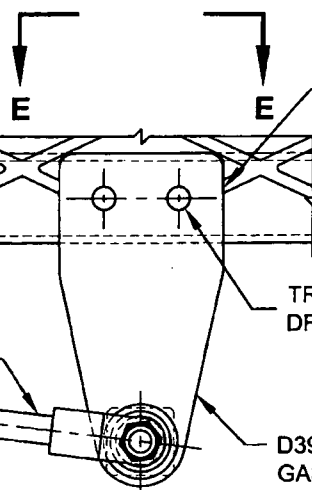
D3953-5
GAS SPRING STUD
REF



TRIM MESH LOCALLY
AS REQUIRED

TRANSFER MARK AND
DRILL Ø0.194 THRU
2 PL

DETAIL B



TRIM MESH LOCALLY
AS REQUIRED

TRANSFER MARK AND
DRILL Ø0.194 THRU

D3953-1
GAS SPRING BRACKET
REF




DETAIL A

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DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

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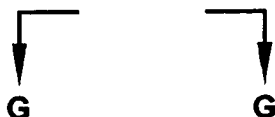
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AN3C15A BOLT
NAS1149C0332R WASHER
MS21043-3 NUT
2 PL

D3953-17
GAS SPRING SPACER
D3953-15
GAS SPRING BRACKET
REF
D3953-7
GAS SPRING SPACER
D3953-9
GAS SPRING WASHER

D3953-3 GAS SPRING STUD
AN310-4 CASTELLATED NUT
MS24665-212 COTTER PIN
NAS1149C0432R WASHER

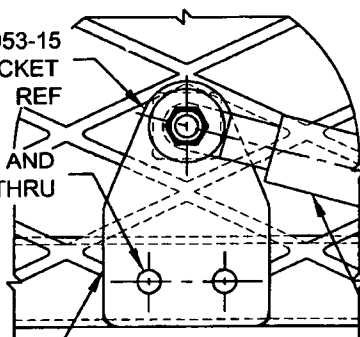
VIEW G-G



D3953-15
GAS SPRING BRACKET
REF
TRANSFER MARK AND
DRILL Ø0.194 THRU

TRIM MESH LOCALLY
AS REQUIRED

DETAIL C



D3969-1
GAS SPRING
REF

AN3C11A BOLT
NAS1149C0332R WASHER
MS21043-3 NUT
2 PL

D3953-5
GAS SPRING STUD
REF
D3953-11
GAS SPRING SPACER
D3953-9
GAS SPRING WASHER

AN310-4 CASTELLATED NUT
MS24665-212 COTTER PIN
NAS1149C0432R WASHER

VIEW H-H

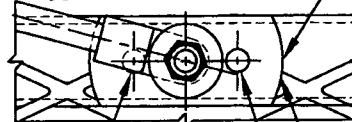


D3953-5
GAS SPRING STUD
REF

TRIM MESH LOCALLY
AS REQUIRED

TRANSFER MARK AND
DRILL Ø0.194 THRU

DETAIL D



D3969-1
GAS SPRING
REF

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 09.11.11
CERT. NO.: SH94-14
ISSUE NO.: 4

DESIGN	AJS
DRAWN	AJS
CHECKED	<i>[Signature]</i>
MFG. APPR.	N/A
APPROVED	<i>[Signature]</i>
DE APPR.	<i>[Signature]</i>
DATE	09.11.11

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.	REV. C
DSI 9473	SHEET 8 OF 8
TITLE	SCALE
AUTOMATIC LID OPENER INSTL	NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

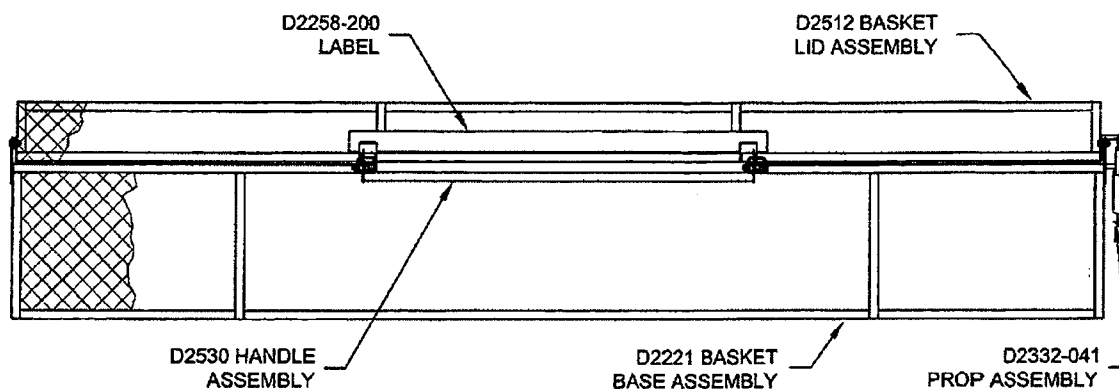
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

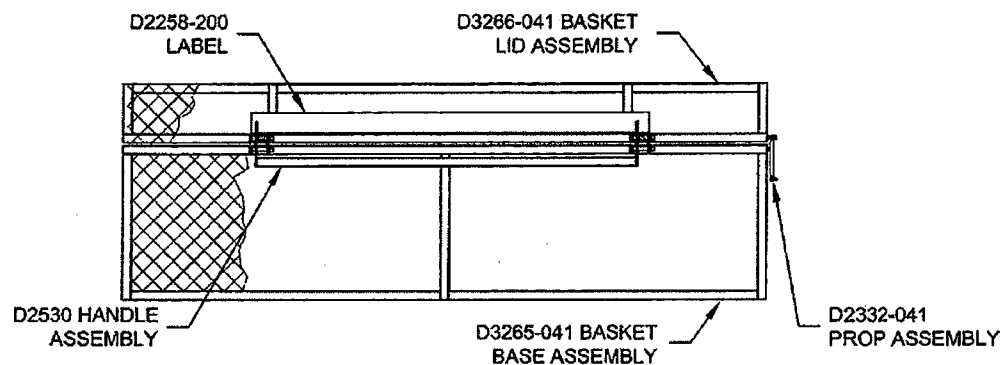
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

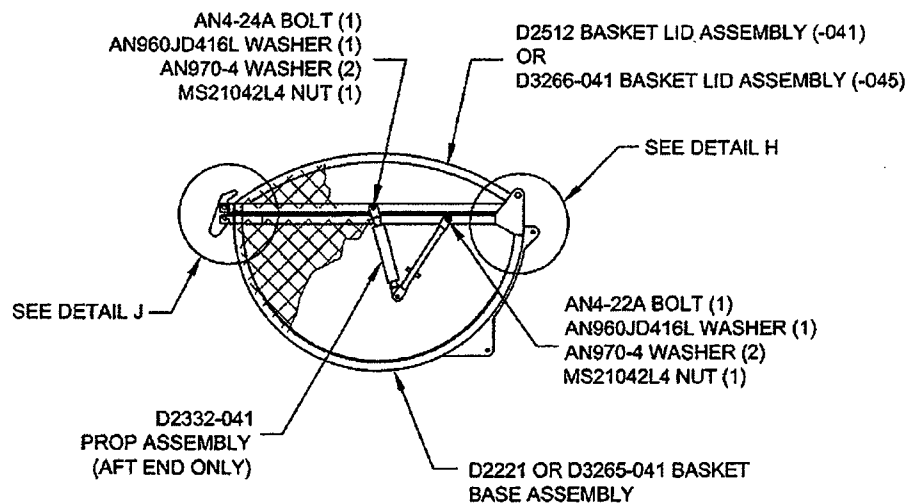
#65042



D350-607-041 HELI-UTILITY- BASKET™



D350-607-045 HELI-UTILITY- BASKET™



VIEW C-C
PROP ARM DETAIL

Figure 5 – Basket Replacement Parts

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Revision: **A**
Date: 10.03.10

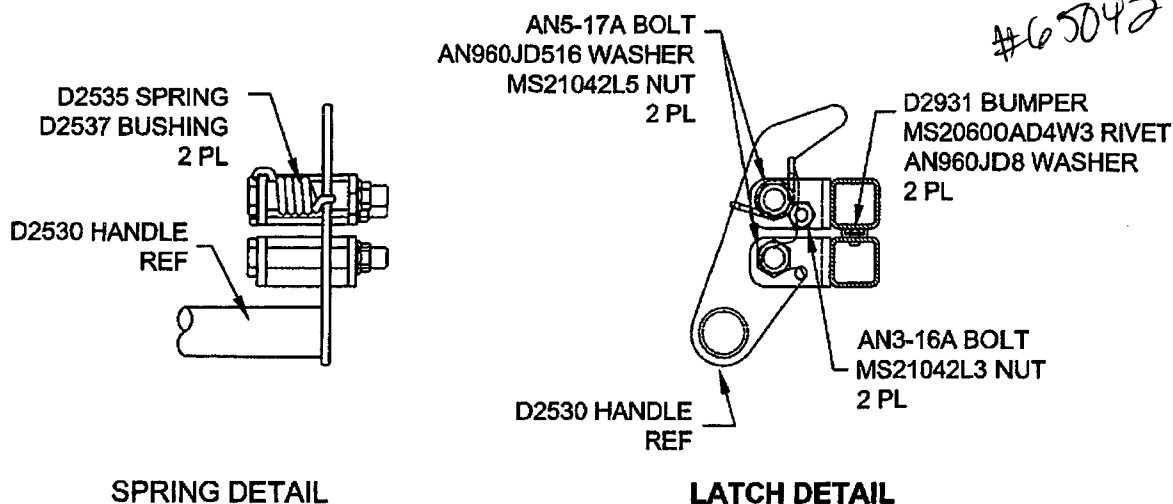
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

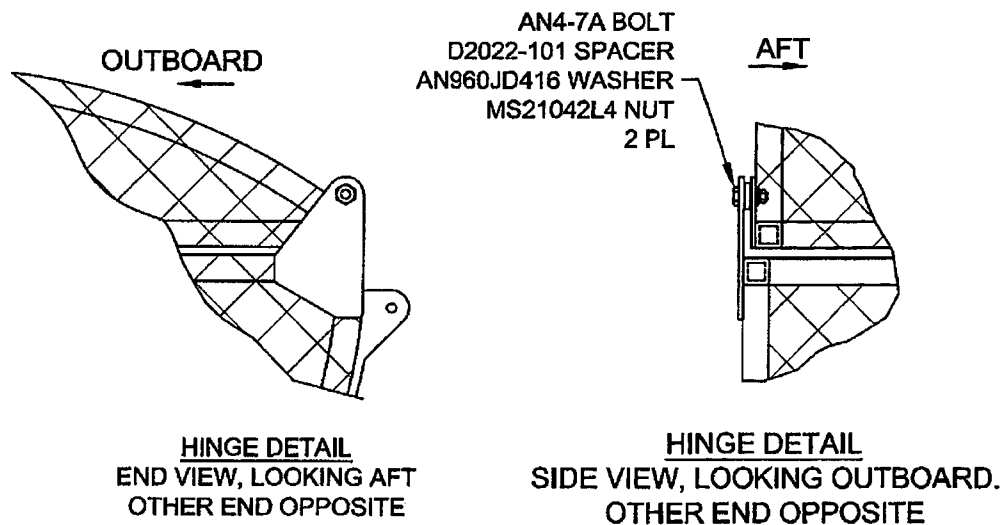
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DETAIL J:
HANDLE WELDMENT



DETAIL H:
HINGE

Figure 7 – Basket Replacement Parts

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Revision: **A**
Date: 10.03.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries